

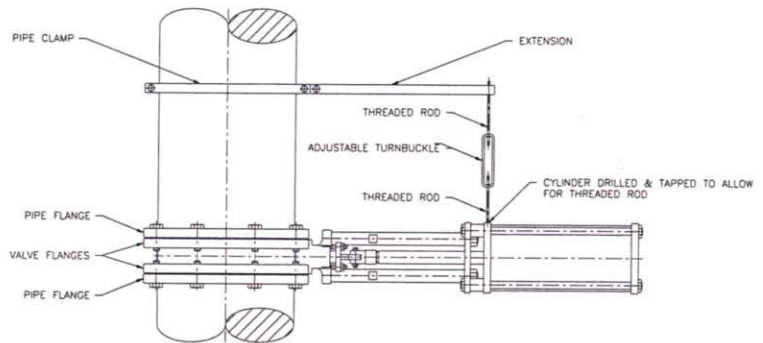
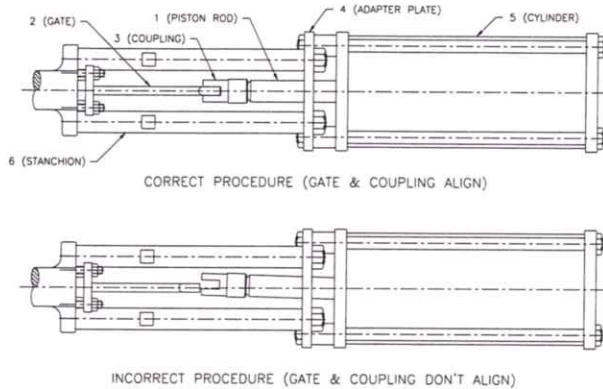
INSTALLATION PROCEDURE FOR KNIFE GATES IN THE HORIZONTAL POSITION

- STEP #1** WHEN SUPPORTING THE CYLINDER, DISCONNECT THE PISTON ROD (ITEM 1) FROM THE GATE (ITEM 2).
- STEP #2** MAKE SURE YOUR CYLINDER SUPPORT HAS AN UP & DOWN ADJUSTMENT OF ABOUT 2" EITHER WAY.
(i.e. A TURNBUCKLE (ADJUSTABLE) WITH A CABLE IS PROBABLY THE BEST DEVICE TO USE)

- STEP #3** APPLY AIR PRESSURE AT THE TOP OF THE CYLINDER ALLOWING THE PISTON ROD & COUPLING (ITEM 3) TO MOVE TOWARDS THE GATE. DISCONNECT THE AIR PRESSURE AS THE COUPLING APPROACHES THE GATE AND SEE IF THE COUPLING WILL FIT DIRECTLY ONTO THE GATE. IF IT DOES NOT, USE THE ADJUSTABLE SUPPORT EITHER UP OR DOWN TO ENSURE THE ALIGNMENT. DO NOT FORCE THE COUPLING ONTO THE GATE.

IF YOU REQUIRE FURTHER ADJUSTMENT, YOU CAN DO SO WITH THE ADAPTER PLATE. FIRST LOOSEN ALL FOUR NUTS ON THE PLATE. THIS WILL GIVE YOU ADDITIONAL ADJUSTMENT.

ONCE THE COUPLING IS ALIGNED, PROCEED TO TIGHTEN ALL NUTS.



IMPORTANT NOTES

- IT IS RECOMMENDED THAT THE GATE BE TREATED WITH HT65
- DO NOT OVER TORQUE THE FLANGE BOLTS (REFER TO THE TORQUE CHART AT THE BOTTOM OF THIS PAGE).

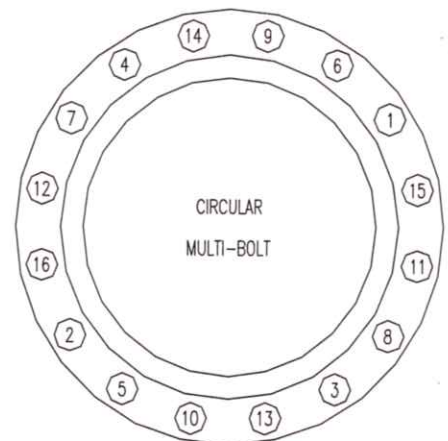
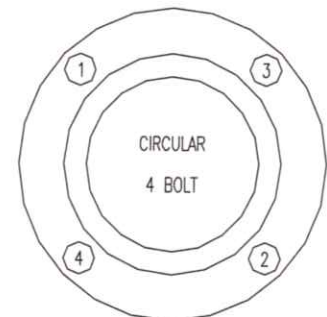
RECOMMENDED INSTALLATION STUD OR BOLT TORQUES FOR KNIFE GATE VALVES

Important! Must be read prior to installation.

Recommended Minimum & Maximum Bolt Torques
Machined Bolts & Cold Roll Steel Studs

Nominal Size	Stud or Bolt Size	Min. Torque Lubed (ft/lb)	Max. Torque Lubed (ft/lb)
2" ~ 4"	5/8"-11 UNC	32	38
6" & 8"	3/4"-10 UNC	56	65
10" & 12"	7/8" - 9 UNC	54	63
14" & 16"	1" - 8 UNC	82	95
18" & 20"	1 1/8"-7 UNC	117	135
24" & 30"	1 1/4"-7 UNC	165	190
36" ~ 48"	1 1/2"-6 UNC	282	325

* For alloy steel (B-7) bolts call Trueline



INSTALLATION

- Tighten bolts or studs to compress the flange uniformly. This means going from side to side around the flange according to proper bolting patterns (refer to diagram).
- Use a torque wrench and well lubricated fasteners with flat washers to ensure correct initial loading.
- All bolts should be tightened in one-third increments, according to proper bolting patterns (refer to diagram).